

Work Order ID 154391

Monday, December 12, 2016 2:26:24 PM

154391

Page 1

Item ID: 647.7328

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: EC135 T3/P3 Upper Cutter Removable Provisions

Start Date: 12/12/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 12/16/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

DEC 15 2016

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
MPA-195	N/C								DAS 21 9-89 16-12-16
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPP 647.7328								
						DAS 27 9-89		DEC 19 2016	
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
						DAS 6 9-89		DEC 15 2016	DAS 28 9-89
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									
						DAS 27 9-89		DEC 19 2016	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : _____					

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N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Start Date: 12/12/2016 **Start Qty:** 1.00 ***1***

Customer:

Required Date: 12/16/2016 **Req'd Qty:** 1.00 ***1***

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

0.00

130

Packaging

0.00

Packaging

Memo

Packaging

Identify and pack for shipping as per PPP 647.7328
Location : FG109

DAS
28
9-89

DAS
27
9-89

DEC 19 2016

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

DAS
21
9-89

DEC 19 2016

DAS
21
9-89

DEC 19 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval 	
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	

Root Cause				FAULT CATEGORY			
Environment ☐	☐	No Re-verification ☐	☐	Pressure/Forced ☐	☐	Temperature/Cure ☐	☐
Design ☐	☐	Operator ☐	☐	Bending ☐	☐	Set-up ☐	☐
Doc/Data ☐	☐	Offset/Setup ☐	☐	Centre Not Concentric ☐	☐	BOM/Route ☐	☐
Equip/Tooling ☐	☐	Supplier ☐	☐	Cracks ☐	☐	Broken/Damage/Defect ☐	☐
Handling/Pre ☐	☐	Training ☐	☐	Crimp/Kink/Ripple/Wave ☐	☐	Inspection Incomplete/Unqualified ☐	☐
Material ☐	☐	Use for Testing ☐	☐	Cuffs ☐	☐	Contamination ☐	☐
Internal Transport ☐	☐	Poor Information ☐	☐	Crushing ☐	☐	Countersink ☐	☐
Tribal Knowledge ☐	☐	Rushing ☐	☐	Heat Treat ☐	☐	Cut Too Short ☐	☐
LOA ☐	☐	Product Improvement ☐	☐	Wave/Twist in Tube ☐	☐	Instructions Incomplete/Unclear ☐	☐
Substation ☐	☐	Process Improvement ☐	☐	Marks/Chatter ☐	☐	Drill Holes ☐	☐
Past Expiry Date ☐	☐	Manufacturing Process ☐	☐	OTHER : _____			
Misidentified ☐	☐	Past Due ☐	☐				

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647 7328

Required Date: 12/16/2016

Required Qty: 1.00

Comments: IPP REV:A 16.12.12 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
647.7701		Manufactured	No				Each	0.0000		2			
647 7701									**				
Strut Assembly													
647.0112		Manufactured	No				Each	41.0000		2			
647 0112									**				
Strut Bracket													
				<u>Location</u>			<u>Loc Qty</u>			<u>Loc Code</u>			
				CCK107			41						
				150114			16						
				150895			15						
				151894			10						
AN44-12A		Purchased	No				Each	12.0000		2			
AN44-12A									**				
Eyebolt													
				<u>Location</u>			<u>Loc Qty</u>			<u>Loc Code</u>			
				ST339			12						
				124263			12						
AN665-34R		Purchased	No				Each	84.0000		2			
AN665-34R									**				
Clevis													
				<u>Location</u>			<u>Loc Qty</u>			<u>Loc Code</u>			
				over008			47						
				153852			47						
				ST330			37						
				M135948			11						
				M136182			26						

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER :																							
Misidentified ☐	Past Due ☐																								

Picklist Print

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Work Order ID: 154391

154391

Parent Item: 647.7328

647 7328

Parent Item Name: EC135 T3/P3 Upper Cutter Removable Provisions

Start Date: 12/12/2016

Required Date: 12/16/2016

Start Qty: 1.00

Required Qty: 1.00

AN3-11A

Purchased

No

Each

686.0000

2

AN3-11A

Bolt

**

DEC 19 2016

DAS 6 28 9-89

Location

Loc Qty

Loc Code

over003

664

153855

564

m136192

100

ST349

22

m135767

22

Each

136.0000

2

**

DEC 19 2016

DAS 6 28 9-89

AN4C7A

Purchased

No

AN4C7A

BOLT

Location

Loc Qty

Loc Code

OVER002

124

m135864

70

m136295

54

ST345

12

m135470

12

Each

0.0000

2

**

DEC 19 2016

DAS 6 28 9-89

MS21042-08

MS21042L08

Purchased

No

MS21042-08

USE MS21042L08

DAS 28 9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:12.5%;">Skid-tube ☐</td> <td style="width:12.5%;">Cross tube ☐</td> <td style="width:12.5%;">Water Jet ☐</td> <td style="width:12.5%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Picklist Print

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Work Order ID: 154391

154391

Parent Item: 647.7328

647 7328

Parent Item Name: EC135 T3/P3 Upper Cutter Removable Provisions

Start Date: 12/12/2016

Required Date: 12/16/2016

Start Qty: 1.00

Required Qty: 1.00

MS21042L4

Purchased

No

Each

2,602.000

2

MS21042L4

Nut

**

68-6
9
DAS
28
9-89

DEC 19 2016

Location

Loc Qty

Loc Code

FP001

18

m133363

18

GA

196

m135058

196

OVER007

1500

m136182

500

m136295

1000

ST303

888

153851

3

m135864

385

m135979

500

2

AN316C4R

Purchased

No

Each

89.0000

2

AN316C4R

Nut, Jam

**

68-6
9
DAS
28
9-89

DEC 19 2016

Location

Loc Qty

Loc Code

ST331

89

153850

50

m135840

4

m136192

35

2

MS27039-08-13

Purchased

No

Each

471.0000

2

MS27039-08-13

Screw

**

68-6
9
DAS
28
9-89

DEC 19 2016

Location

Loc Qty

Loc Code

over006

325

153849

325

ST278

146

124326

46

m136199

100

2

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Shop Packet Print

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Picklist Print

Monday, December 12, 2016 2:26:38 PM

Page 4

Work Order ID: 154391

154391

Parent Item: 647.7328

647 7328

Parent Item Name: EC135 T3/P3 Upper Cutter Removable Provisions

Start Date: 12/12/2016

Required Date: 12/16/2016

Start Qty: 1.00

Required Qty: 1.00

NAS1149FN832P

Purchased

No

Each

2,081.000

19

NAS1149FN832P

Washer

DEC 19 2016

68-6

9

SVC

DAS

28

9-89

DAS

27

9-89

DAS

28

9-89

Location

Loc Qty

Loc Code

GA

449

M135058

449

ST260a

1500

M136182

1500

ST263

132

M135058

132

Each

1,775.000

4

NAS1149C0432R

Purchased

No

NAS1149C0432R

WASHER

DEC 19 2016

68-6

9

SVC

DAS

28

9-89

DAS

28

9-89

DAS

27

9-89

Location

Loc Qty

Loc Code

GA

373

m134676

373

ST260a

1000

m136182

1000

ST266

402

m135979

402

Each

1,629.000

2

NAS1149F0532P

Purchased

No

NAS1149F0532P

Washer

DEC 19 2016

68-6

9

SVC

DAS

28

9-89

DAS

27

9-89

DAS

28

9-89

Location

Loc Qty

Loc Code

ST260a

600

m133725

600

ST262

1029

18057

1029

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Page 4

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
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Date : _____		Step # : _____		QTY Effective : _____			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																		
Description Work Order Deviation				Disposition																					
Root Cause		FAULT CATEGORY																							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐																				
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____																							
Misidentified ☐	Past Due ☐																								

Picklist Print

Monday, December 12, 2016 2:26:38 PM

Page 5

Work Order ID: 154391

154391

Parent Item: 647.7328

647 7328

Parent Item Name: EC135 T3/P3 Upper Cutter Removable Provisions

Start Date: 12/12/2016

Required Date: 12/16/2016

Start Qty: 1.00

Required Qty: 1.00

601.2045

Purchased

No

Each

15.0000

1

601 2045

RTV (LOCTITE 598)

**

DEC 19 2016

DAS
6
9-89

DAS
27
9-89

DAS
27
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

CCK096

7

m136171

7

GA

8

m134260

8

MS27039-08-19

Purchased

No

Each

267.0000

5

MS27039-08-19

Screw

**

DEC 19 2016

134702

DAS
27
9-89

Location

Loc Qty

Loc Code

GA

164

m135948

164

ST277

103

m136042

1

m136199

52

m136301

50

MS21042L08

Purchased

No

Each

929.0000

5

MS21042L 08

Nut

**

DEC 19 2016

DAS
27
9-89

Location

Loc Qty

Loc Code

GA

528

m135274

28

m135978

500

ST303

401

m135948

1

m136199

200

m136301

200

DAS
28
9-89

DAS
27
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step # : _____		QTY Effective : _____			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

Monday, December 12, 2016 2:26:38 PM

Page 6

Work Order ID: 154391

154391

Parent Item: 647.7328

647 7328

Parent Item Name: EC135 T3/P3 Upper Cutter Removable Provisions

Start Date: 12/12/2016

Required Date: 12/16/2016

Start Qty: 1.00

Required Qty: 1.00

647.1405

Manufactured No

Each

0.0000

1

647 1405

Upper Cutter Assembly

**

133311

DEC 19 2016

DAS
27
9-89

DAS
6
9-89
DAS
28
9-89
DAS
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐			FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		
OTHER : _____					



SUBJECT:
Manufacturing Process Procedure
EC-135 CCK Configuration Management

DOCUMENT NO:
MPP-195
Rev. N/C
12/15/16

Table 9: T3/P3 UC Removable Provisions Kit, 647.7328

FIND #	PART #	DESCRIPTION	QTY
11	647.7701	STRUT ASSY	2
14	647.0112	STRUT BRACKET	2
39	601.3120	EYE BOLT	2
40	601.3119	CLEVIS	2
46	601.2826	BOLT	2
48	601.2669	BOLT	2
52	601.2973	LOCKNUT	2
54	601.3209	LOCKNUT	2
55	601.3128	NUT	2
61	601.2988	SCREW	2
85	601.2764	WASHER	19
87	601.3663	WASHER	4
88	601.3126	WASHER	2
91	601.2045	RTV	A/R
96	647.5701	GPS MOUNT KIT	1
100	601.2765	SCREW	5
101	601.1541	LOCKNUT	5
111	647.1405	CUTTER ASSY (UPPER)	1

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 154391
DEC 15 2016



REFERENCE ONLY

SUBJECT:
Manufacturing Process Procedure
EC-135 CCK Configuration Management

DOCUMENT NO:
MPP-195
Rev. N/C
12/15/16

Table 9: T3/P3 UC Removable Provisions Kit, 647.7328

FIND #	PART #	DESCRIPTION	QTY
11	647.7701	STRUT ASSY	2
14	647.0112	STRUT BRACKET	2
39	601.3120	EYE BOLT <i>AN44-12A</i>	2
40	601.3119	CLEVIS <i>AN665-34R</i>	2
46	601.2826	BOLT <i>AN3-11A</i>	2
48	601.2669	BOLT <i>AN4C7A</i>	2
52	601.2973	LOCKNUT <i>MS21042-08</i>	2
54	601.3209	LOCKNUT <i>MS21042L4</i>	2
55	601.3128	NUT <i>AN316C4R</i>	2
61	601.2988	SCREW <i>MS27039-08-13</i>	2
85	601.2764	WASHER <i>NAS1149FN832P</i>	19
87	601.3663	WASHER <i>NAS1149C0432R</i>	4
88	601.3126	WASHER <i>NAS1149F0532P</i>	2
91	601.2045	RTV	A/R
96	647.5701	GPS MOUNT KIT	1
100	601.2765	SCREW <i>MS27039-0827</i>	5
101	601.1541	LOCKNUT <i>MS21042L08</i>	5
111	647.1405	CUTTER ASSY (UPPER)	1

dw-o 5?

*w-o (-08-19) 4 **

154391

Page 1

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 12/12/2016 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 12/16/2016 **Req'd Qty:** 1.00 *** 1 ***

Customer:

Reference:

Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start** ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr _____ Revision Nbr _____

MPP-195

N/C

100 Document Control 0.00

100

Document Control

DC	Memo	0.00
----	------	------

Doc.Control -USB or Paperwork Photocopy bluefile & type labels per PPP 647.7328

110	Pick Kit	0.00
-----	----------	------

110

Packaging	Memo	0.00
-----------	------	------

Packaging

120	QC4- 100% Inspect kits for completeness	0.00
-----	---	------

120

QC	Memo	0.00
----	------	------

Quality Control

Marie Lajeunesse

From: Kim Johnston
Sent: Friday, December 16, 2016 9:51 AM
To: Marie Lajeunesse
Subject: FW: EC135 CCK MPP & IIN corrections

Thanks,

Kim Johnston
*Engineering Clerk
Document Administrator*

DART AEROSPACE
T 1 613 632-5200 > ext. 226
F 1 613 632-9311



From: Sian Willems
Sent: Monday, December 12, 2016 9:21 AM
To: Lisa McMachen <lcmachen@dartaero.com>; Kim Johnston <kjohnston@dartaero.com>
Subject: RE: EC135 CCK MPP & IIN corrections

Go ahead and load. A corrected version will follow once DaveM makes the updates.

SIAN WILLEMS
Customer Support Manager

DART AEROSPACE
T +1-613-632-3336 > 239
M +1-613-676-0577
F +1-613-632-5146
+1-800-556-4166
www.dartaerospace.com

From: Lisa McMachen
Sent: Monday, December 12, 2016 8:26 AM
To: Kim Johnston <kjohnston@dartaero.com>; Sian Willems <swillems@dartaero.com>
Subject: FW: EC135 CCK MPP & IIN corrections

Hi Sian,
Kim says that the paperwork is not jiving...can we load the attached documents to the website as discussed on Friday? Please see the attached email.

Thanks,
Lisa McMachen

From: Sian Willems
Sent: Monday, December 12, 2016 7:21 AM